



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9701

Job Sheet 205295



Part No: 646.9701

Job Qty: 4 pcs

Part Name: Cutter Sub Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/7/20

Job Tracking No:

Due Date: 2/10/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 646.9701 REV.H IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS IPP REV :B AS PER REV D 16-03-07
JLM VERIFIED BY:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		2/10/20	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Part: 646.9701
Job No: 205295
Serial No/Batch: S253817
Revision: H
Inspector:
Exp Date:
Instructions:

Date: 02/06/20



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartero.com
www.darterospace.com

DAS
84
9-89

Plex 1/7/20 9:08 AM Dart.lajeunesse.marie

1/7/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 Small Fab - 2 - B4B	4 pcs	2/10/20	0.00 0.11	Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				Packaging 1 - 37	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
130 QC 5	4 pcs	2/10/20	0.00 0.00	Small Fab - 4 - B4B	FEB 10 2020
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
140 Packaging 3-1 - Stock - B4B	4 pcs	2/10/20	0.00 0.00	QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	

DAS
81
9-89

FEB 10 2020

DAS
41
9-89

FEB 10 2020

Plex 1/7/20 9:08 AM Dart.lajeunesse.marie

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	4 pcs	2/10/20	0.00 0.00	QC 21 - SA - 21	FEB 10 2020
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note . A/R RTV LOCTITE

598: 5253009 exp. date: 02/21

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: ck007) ***IDENTIFY AS PER IAW MPP-120***

150 - (QC21- Final Inspection - Work Order Release)

013956

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.9710	Body	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5205257
646.9711	Blade	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	522911781
MS21042L08	Nut	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	523128X20/525010X4
MS27039-08-19	Screw	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	5231293
NAS1149FN832P	Washer (AN960-8)	48 Ea (12 ea)	110-Packaging 1 - Pick Kit	5235228

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.9710	4	21	0
	646.9711	8	7	0
	MS21042L08	24	355	0
	MS27039-08-19	24	531	0
	NAS1149FN832P	48	726	0

Part Specifications

Specifications could not be found.

Plex 1/7/20 9:08 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			

